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**D4018-041**  
**Job Sheet 190492**



**Part No:** D4018-041

**Job Qty:** 1 pcs

**Part Name:** AS350 Short Basket Lid Assembly



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 2/11/19

**Job Tracking No:**

**Due Date:** 3/8/19

**Created By:** Marie Lajeunesse

**Type:** SOLD

**Description:**

**Note:** DWG D4020 REV A, D4018 REV E SHEETS 1,2,3 IPP RevA: new issue DD 09.11.30 verified by:EC IPP  
Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP  
Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP REV:E 13.08.21 DWG REV.D / ECN 13-624 DD  
VERF:JLM

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty      | Start Date | Due Date | Standard |      | Workcenter/Supplier             | Sign-off |
|-------|------------------------|----------|------------|----------|----------|------|---------------------------------|----------|
|       |                        |          |            |          | Setup    | Run  |                                 |          |
|       |                        |          |            |          | Hrs      | Hrs  | Workcenter / Supplier Lead Time |          |
| 100   | Large Fab - Basket - 1 | 1<br>pcs | 3/8/19     |          | 0.00     | 7.69 | Large Fab - 1                   |          |
|       |                        |          |            |          |          |      | Large Fab - 10                  |          |
|       |                        |          |            |          |          |      | Large Fab - 2                   |          |
|       |                        |          |            |          |          |      | Large Fab - 3                   |          |
|       |                        |          |            |          |          |      | Large Fab - 4                   |          |
|       |                        |          |            |          |          |      | Large Fab - 5                   |          |
|       |                        |          |            |          |          |      | Large Fab - 6                   |          |
|       |                        |          |            |          |          |      | Large Fab - 7                   |          |
|       |                        |          |            |          |          |      | Large Fab - 8                   |          |
| 110   | QC 9                   | 1<br>pcs | 3/8/19     |          | 0.00     | 0.00 | Large Fab - 9                   |          |
|       |                        |          |            |          |          |      | QC 9 - 10                       |          |
|       |                        |          |            |          |          |      | QC 9 - 18                       |          |
|       |                        |          |            |          |          |      | QC 9 - 24                       |          |
|       |                        |          |            |          |          |      | QC 9 - 43                       |          |
|       |                        |          |            |          |          |      | QC 9 - 50                       |          |
| 120   | QC 5                   | 1<br>pcs | 3/8/19     |          | 0.00     | 0.00 | QC 9 - 9                        |          |
|       |                        |          |            |          |          |      | QC 5 - 10                       |          |
|       |                        |          |            |          |          |      | QC 5 - 12                       |          |
|       |                        |          |            |          |          |      | QC 5 - 17                       |          |
|       |                        |          |            |          |          |      | QC 5 - 18                       |          |
|       |                        |          |            |          |          |      | QC 5 - 19                       |          |
|       |                        |          |            |          |          |      | QC 5 - 22                       |          |
|       |                        |          |            |          |          |      | QC 5 - 24                       |          |
|       |                        |          |            |          |          |      | QC 5 - 3                        |          |
|       |                        |          |            |          |          |      | QC 5 - 42                       |          |
|       |                        |          |            |          |          |      | QC 5 - 43                       |          |
|       |                        |          |            |          |          |      | QC 5 - 49                       |          |
|       |                        |          |            |          |          |      | QC 5 - 51                       |          |
|       |                        |          |            |          |          |      | QC 5 - 58                       |          |

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|                                      |       |        |           |                                            |           |           |
|--------------------------------------|-------|--------|-----------|--------------------------------------------|-----------|-----------|
|                                      |       |        |           |                                            | QC 5 - 68 |           |
|                                      |       |        |           |                                            | QC 5 - 9  |           |
|                                      |       |        |           |                                            | QC 5 - 50 |           |
|                                      |       |        |           |                                            | QC 5 - 30 |           |
| 130 Powdercoat - 4 Black Sand - B4B  | 1 pcs | 3/8/19 | 0.00 0.42 | Powdercoat - 1 - B4B                       |           |           |
|                                      |       |        |           | Powdercoat - 2 - B4B                       |           |           |
|                                      |       |        |           | Powdercoat - 3 - B4B                       |           | BP19-0320 |
|                                      |       |        |           | Powdercoat - 4 - B4B                       |           |           |
| START: 8:40 OUT: 300° FINISH: 19:10. |       |        |           |                                            |           |           |
| 140 Handfinish - 3-1- WingWalk-B4B   | 1 pcs | 3/8/19 | 0.00 0.88 | Handfinish - 3 - 1 - B4B                   |           | M 19-3-20 |
|                                      |       |        |           | Handfinish - 3 - 2 - B4B                   |           |           |
|                                      |       |        |           | Handfinish - 3 - 3 - B4B                   |           |           |
|                                      |       |        |           | Handfinish - 3 - 4 - B4B                   |           |           |
|                                      |       |        |           | Handfinish - 3 - 5 - B4B                   |           |           |
| 150 QC 3                             | 1 pcs | 3/8/19 | 0.00 0.00 | QC 3 - 10                                  |           |           |
|                                      |       |        |           | QC 3 - 13                                  |           |           |
|                                      |       |        |           | QC 3 - 15                                  |           |           |
|                                      |       |        |           | QC 3 - 17                                  |           |           |
|                                      |       |        |           | QC 3 - 18                                  |           |           |
|                                      |       |        |           | QC 3 - 2                                   |           |           |
|                                      |       |        |           | QC 3 - 26                                  |           | DAS       |
|                                      |       |        |           | QC 3 - 28                                  |           | 19        |
|                                      |       |        |           | QC 3 - 3                                   |           | 9-89      |
|                                      |       |        |           | QC 3 - 30                                  |           |           |
|                                      |       |        |           | QC 3 - 34                                  |           |           |
|                                      |       |        |           | QC 3 - 36                                  |           |           |
|                                      |       |        |           | QC 3 - 41                                  |           |           |
|                                      |       |        |           | QC 3 - 51                                  |           |           |
|                                      |       |        |           | QC 3 - 58                                  |           |           |
|                                      |       |        |           | QC 3 - 59                                  |           |           |
|                                      |       |        |           | QC 3 - 6                                   |           |           |
|                                      |       |        |           | QC 3 - 68                                  |           |           |
|                                      |       |        |           | QC 3 - 9                                   |           |           |
| 160 Packaging 3-1 - Stock - B4B      | 1 pcs | 3/8/19 | 0.00 0.00 | Packaging 3 - 1 - B4B                      |           |           |
|                                      |       |        |           | Packaging 3 - 2 - B4B                      |           |           |
|                                      |       |        |           | Packaging 3 - 3 - B4B                      |           |           |
|                                      |       |        |           | Packaging 3 - 4 - B4B                      |           |           |
|                                      |       |        |           | Packaging 3 - 5 - B4B                      |           |           |
|                                      |       |        |           | Packaging 3 - 6 - B4B                      |           |           |
|                                      |       |        |           | Packaging 3 - 7 - B4B                      |           |           |
|                                      |       |        |           | Packaging 3 - 8 - B4B                      |           |           |
|                                      |       |        |           | Packaging 3 - 9 - B4B                      |           |           |
|                                      |       |        |           | Packaging 3 - 10 - B4B                     |           |           |
|                                      |       |        |           | Packaging 3 - 11 - B4B                     |           |           |
|                                      |       |        |           | Packaging 3 - 12 - B4B                     |           |           |
|                                      |       |        |           | Packaging 3 - 13 - B4B                     |           |           |
|                                      |       |        |           | Packaging 3 - 14 - B4B                     |           |           |
|                                      |       |        |           | Packaging 3 - 15 - B4B                     |           |           |
|                                      |       |        |           | Packaging 3 - 16 - B4B                     |           |           |
|                                      |       |        |           | Packaging 3 - 17 - B4B                     |           |           |
|                                      |       |        |           | Packaging 3 - 18 - B4B                     |           |           |
|                                      |       |        |           | Packaging 3 - 19 - B4B                     |           |           |
|                                      |       |        |           | Packaging 3 - 20 - B4B                     |           |           |
|                                      |       |        |           | Packaging 3 - 21 - B4B                     |           |           |
|                                      |       |        |           | Packaging 3 - 22 - B4B                     |           |           |
|                                      |       |        |           | Packaging 3 - 23 - B4B                     |           |           |
|                                      |       |        |           | Packaging 3 - 24 - B4B                     |           |           |
|                                      |       |        |           | Packaging 3 - 25 - B4B                     |           |           |
|                                      |       |        |           | Packaging 3 - 26 - B4B                     |           |           |
|                                      |       |        |           | Packaging 3 - 27 - B4B                     |           |           |
|                                      |       |        |           | Plex 2/11/19 7:24 AM Dart.lajeunesse.marie |           |           |



|                |          |        |           |  |                        |                |
|----------------|----------|--------|-----------|--|------------------------|----------------|
|                |          |        |           |  | Packaging 3 - 28 - B4B |                |
|                |          |        |           |  | Packaging 3 - 29 - B4B |                |
|                |          |        |           |  | Packaging 3 - 30 - B4B |                |
|                |          |        |           |  | Packaging 3 - 31 - B4B |                |
|                |          |        |           |  | Packaging 3 - 32 - B4B |                |
|                |          |        |           |  | Packaging 3 - 33 - B4B |                |
|                |          |        |           |  | Packaging 3 - 34 - B4B |                |
|                |          |        |           |  | Packaging 3 - 35 - B4B |                |
| 170 QC 21 - SA | 1<br>pcs | 3/8/19 | 0.00 0.00 |  | QC 21 - SA - 21        | 21 MAR 20 2019 |
|                |          |        |           |  | QC 21 - SA - 70        | 21 MAR 20 2019 |
|                |          |        |           |  | QC 21 - SA - 53        | 21 MAR 20 2019 |

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: \_\_\_\_\_) 1- assemble ribs , weld as per dwg D4018 using DT9607B 2- weld Descriptions: hinge (3) and Mounting brackets as per dwg D4018 \*\*\*inspect before welding mesh\*\*\* 3- Cut mesh as per dwg D4020-7 4- tack weld mesh on basket as per dwg D4018 \*\*\*make sure to place mesh correctly on lid, check with label plate before tacking mesh\*\*\*

110 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) \*\*\* mask sides of hinge prior to powdercoat\*\*\*

140 - (Wing Walk as per dwg QSI005 4.4 Batch \_\_\_\_\_) 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg Install placard and label as per dwg

150 - (QC3- Inspect Part Finish)

160 - (Identify as per dwg & Stock Location: \_\_\_\_\_)

170 - (QC21- Final Inspection - Work Order Release)

Master Unit #008631

### Job BOM

| Part / Item      | Component Name                     | Quantity        | Operation                  | Container                     |
|------------------|------------------------------------|-----------------|----------------------------|-------------------------------|
| D2581 ✓          | Mounting Bracket                   | 2 pcs (2 ea) ✓  | 100-Large Fab - Basket - 1 | \$ 155.29                     |
| D4016-3 ✓        | Hinge Half, Lid                    | 3 pcs (3 ea) ✓  | 100-Large Fab - Basket - 1 | \$ 110.937                    |
| D4018-1 ✓        | Rib                                | 2 pcs (2 ea) ✓  | 100-Large Fab - Basket - 1 | 2X \$ 117.158 / 1X \$ 117.158 |
| D4018-3 ✓        | Rib                                | 2 pcs (2 ea) ✓  | 100-Large Fab - Basket - 1 | \$ 127.804                    |
| D4018-5 ✓        | Rib                                | 6 pcs (6 ea) ✓  | 100-Large Fab - Basket - 1 | 5X \$ 161.565 / 1X \$ 161.565 |
| D4021-3 ✓        | Data Plate                         | 1 pcs (1 ea) ✓  | 100-Large Fab - Basket - 1 | \$ 154.112                    |
| D4035-043 ✓      | Lid Rib Assembly, Aft (350 Basket) | 2 pcs (2 ea) ✓  | 100-Large Fab - Basket - 1 | \$ 159.249                    |
| M304EX0.75-16F ✓ | Expanded Metal Flat SS             | 16 sf (16 ea) ✓ | 100-Large Fab - Basket - 1 | \$ 147.379                    |

### Job Allocations

| Operation                  | Component Part | Required | Inventory | Allocated |
|----------------------------|----------------|----------|-----------|-----------|
| 100-Large Fab - Basket - 1 | D2581          | 2        | 69        | 0         |
|                            | D4016-3        | 3        | 144       | 0         |
|                            | D4018-1        | 2        | 6         | 0         |
|                            | D4018-3        | 2        | 6         | 0         |
|                            | D4018-5        | 6        | 54        | 0         |
|                            | D4021-3        | 1        | 3         | 0         |
|                            | D4035-043      | 2        | 4         | 0         |
|                            | M304EX0.75-16F | 16       | 1,934     | 0         |

### Part Specifications

Specifications could not be found.

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                        |              |  |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------|--------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                        |              |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                        | MRB (QSI042) |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Disposition            |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Completed By           |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Lead hand / Supervisor |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | QC / QA Coordinator    |              |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column; align-items: flex-start;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |                        |              |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                        |              |  |



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**Container No: S162891**



**Part: D4018-041**

**Job No: 190492**

**Serial No/Batch: S162891**

**Revision:**

**Inspector:**

**Exp Date:**

**Instructions: Various STC's**

**Date: 03/15/19**